

# Work Order ID 67961 - 1

Tuesday, April 05, 2011 10:10:20 AM



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Item ID: D412-698-012

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 4/5/2011 Start Qty: 2.00

Required Date: 4/11/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-04-11 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

8/15/12

11-04-11 labels

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

JB 11/04/11

120

QC4- 100% inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/15/12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 67961**

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Item ID: D412-698-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-012  
Location: 62 2403

11/5/10

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

ME

11-05-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 67961

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH



Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from  
Step 1.3 KJ/DS  
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3121-141



Bracket Assembly -3

Manufactured

No

110

Each

0.0000

3

6



67783x3 JB

D3121-144



Bracket Assembly

Manufactured

No

110

Each

3.0000

1

2



68205 JB

Location

Loc Qty

Loc Code

ST235A

3

61728

3

D3137-043



Bracket Assembly

Manufactured

No

110

Each

2.0000

1

2



68243 Co

Location

Loc Qty

Loc Code

ST235B

2

62831

2

D3183-044



Bracket Assembly

Manufactured

No

110

Each

3.0000

1

2



67775 11/04/20

Location

Loc Qty

Loc Code

ST236

3

61482

3



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 67961

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110 Each

90.0000

9 18 ✓



Bracket

Location

Loc Qty

Loc Code

ST236A

90

61484

40

66830

50

Manufactured No

110 Each

12.0000

1 2 ✓

D3202-1



Cover

Location

Loc Qty

Loc Code

ST241A

12

59693

4

66252

8

368241 2x \$ 11/4/25

66830 x 16X

JB 11/04/20

66252

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Shop Packet Print

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**  
 (FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Part Number  | Description                |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|----------------------------|
| X           |             |             |             |             |             | D412-698-011 | CABIN DOOR ROLLER KIT, LH  |
|             | X           |             |             |             |             | D412-698-012 | CABIN DOOR ROLLER KIT, RH  |
|             |             | X           |             |             |             | D412-698-013 | DOOR HANDLE KIT            |
|             |             |             | X           |             |             | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
|             |             |             |             | X           |             | D412-698-019 | BEARING OVERHAUL KIT       |
|             |             |             |             |             | X           | D412-698-021 | REPLACEMENT SHIM KIT       |
| 3           | 3           |             |             |             |             | D3121-141    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3121-143    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3121-144    | BRACKET ASSEMBLY           |
| 1           | 1           |             |             |             |             | D3137-043    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3183-043    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3183-044    | BRACKET ASSEMBLY           |
| 9           | 9           |             | 9           |             |             | D3199-1      | BRACKET                    |
| 1           | 1           |             | 1           |             |             | D3202-1      | COVER                      |
|             |             | 4           |             |             |             | D3203-1      | HANDLE                     |
|             |             | 1           |             |             |             | D3220-041    | DOUBLER                    |
|             |             | 1           |             |             |             | D3220-042    | DOUBLER                    |
|             |             | 2           |             |             |             | D3220-3      | DOUBLER                    |
|             |             |             |             | 7           |             | D3121-21     | BOLT                       |
|             |             |             |             | 5           |             | D3121-241    | BEARING ASSEMBLY           |
|             |             |             |             | 1           |             | D3137-3      | GUIDE                      |
|             |             |             |             | 1           |             | D3137-5      | WASHER                     |
|             |             |             |             | 2           |             | D3183-045    | BEARING ASSEMBLY           |
|             |             |             |             |             | 3           | D3238-1      | SHIM                       |
|             |             |             |             |             | 1           | D3238-3      | SHIM                       |
|             |             |             |             |             | 2           | D3238-5      | SHIM                       |
|             |             |             |             |             | 6           | D3238-11     | SHIM                       |
|             |             |             |             |             | 2           | D3238-13     | SHIM                       |
|             |             |             |             |             | 4           | D3238-15     | SHIM                       |
|             |             | 8           |             |             |             | AN960JD416L  | WASHER                     |
|             |             | 8           |             |             |             | MS21042L4    | NUT (OR MS21042-4)         |
|             |             | 16          |             |             |             | MS24694-S98  | SCREW                      |
|             |             |             |             | 1           |             | MS24694-S101 | SCREW                      |

